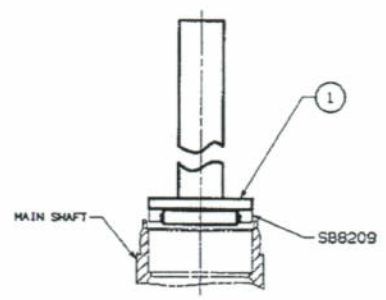
OPERATING INSTRUCTIONS SHT 1 OF 2

TOOL NO:76351-09600-044T046 REV:---
PART NO:76351-09600-044 DP.NO:233
FUNCTION: INSTALL SEAL

1.) MOUNT SEAL (SB8209) ON TO PUSHER (DET #1).
2.) INSTALL SEAL PER O/S.



OPERATING INSTRUCTIONS SHT#2 OF #2

TOOL NO:76351-09600-044T046 REV:---
PART NO:76351-09600-044

THE FOLLOWING INFORMATION IS MANDATORY FOR THIS TOOL:

MAX.FORCE PERMISSIBLE ON THESE PARTS: 3,000 LBS.
DESIGN ENGR.APPVL.&DATE: JOHN BALDGYA, 6/28/94

MACHINE FORCE TO APPLY 1,500 LBS FOR THIS OPERATION
(MAYBE OBTAINED BY MEASURED FORCE AT 1ST PIECE SET-UP & DOCUMENTED ABOVE: ALSO NOTIFY TOOL DESIGN OF THE ACTUAL FORCE REQUIRED SO AS TO UPDATE TOOL DESIGN.)

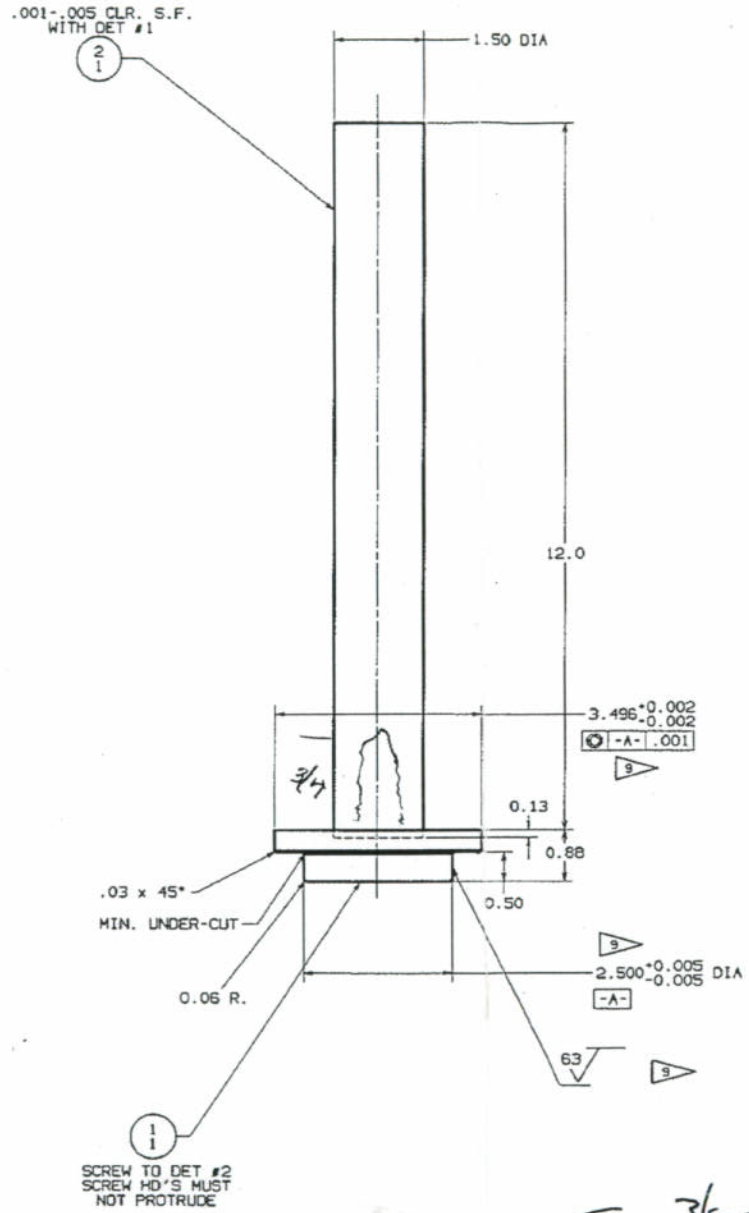
DESIGN ENGINEER'S APPROVAL FOR THE LOCATION OF APPLIED FORCES & REACTION OF THE PART.
DESIGN ENGR.APPVL.&DATE: JOHN BALDGYA, 6/28/94

HEATING &/OR COOLING OF COMPONENTS REQUIRED PRIOR TO ASSY.

YES		NO		OPTIONAL	X

(CHECK APPLICABLE BOX FOR SPECIFIC APPLICATION.)

NOTE:THIS DESIGN HAS COMPLIED WITH PLANNING ALERT#89028.



3/8 x 1 1/2 SOC HD CS.
TAP 3/8-24 x 3/4 in handle
DW 3/8/09
TAP 3/4 bp
QUOTE

DESIGN PER 76351-09600-044T046
TDD CHG. 001

REVISIONS

LET	CHANGE	BY DATE	APPVL DATE

-NOTE-

1. THIS DESIGN WAS PREPARED UNDER CONTRACT NUMBER _____ ENGINEERING DRAWING: _____ REV. ___ A/F _____
2. TOOL TO BE STAMPED WITH TOOL NUMBER, REVISION, CONTRACT NUMBER, PROPERTY OF, AND TOOL WEIGHT. REFER TO FABRICATION TDD FOR COMPLETE STAMPING INFORMATION.
3. SCREW AND DOWEL AS REQ'D IN F/D. LOCATION AND HOLE PREPARATION MUST SUIT GOOD TOOLMACING PRACTICES. DOWELS TO BE P.F. UNLESS OTHERWISE NOTED
4. PURCHASE STANDARD ITEMS PER B/M OR EQUIVALENT UNLESS OTHERWISE NOTED
5. THIS TOOL'S WEIGHT IS APPROX. 2.8 POUNDS. THIS TOOL'S VOLUME IS APPROX. .09 CUBIC FEET. LENGTH 13 WIDTH 3.5 HEIGHT 3.5 (IN INCHES)
6. PROVIDE A DURABLE WOODEN STORAGE BOX FOR ENTIRE TOOL. BOX TO HAVE HINGING TOP & LOCKING HASP WHERE APPROPRIATE. BOX TO HAVE SUITABLE CORNER REINFORCEMENT AND LIFTING FEATURES. BOX CONSTRUCTION TO BE OF .50 MIN. THK. PLYWOOD, PINE OR HARD WOOD. GLUE AND/OR SCREWS MAY BE USED (NO NAILS). ENTIRE EXTERIOR AND INSIDE COVER OF BOX TO BE PAINTED WITH BLACK PAINT GLIDDEN #8951 HIGH PERFORMANCE ACRYLIC COATING, OR EQUIVALENT. TOOL NUMBER TO BE STENCILED ON FRONT AND TOP SIDE OF BOX EXTERIOR USING WHITE PAINT. CHARACTER HEIGHT TO BE .750 TO 1.50 HIGH AND SUIT STORAGE BOX SIZE.
7. MAKE A "XEROX" OR B/P COPY OF OPERATING INSTRUCTIONS, SANDWICH BETWEEN (2) SHEETS OF CLEAR PLASTIC & FASTEN TO INSIDE COVER OF STORAGE BOX. OPERATING INSTRUCTIONS MAY BE REDUCED TO FIT STORAGE BOX COVER.
8. FILL ALL STAMPINGS WITH CONTRASTING COLOR PAINT.

9 FEATURES IDENTIFIED WITH THIS 9 SYMBOL IN THE FIELD OF DRAWING ARE KEY FEATURES AND SHALL BE INSPECTED AND VERIFIED BY S/A INSPECTION DEPT.

SHOP COPY

RELEASED FOR PROD.
DATE: 3/24/09 INT: EMB

10137 PISTOL CASE

DET	QTY	NAME	MATL	FINISH STOCK SIZE
3	1	SOHCS 3/8-24		3/8 R x 1 1/2
2	1	ROD	PBS 2222	1.00 DIA X 12.13 LG.
1	1	PUSH HEAD	PBS 2222	3.496 DIA X .98 THK.

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UNITED TECHNOLOGIES PRATT & WHITNEY STRATFORD, CONN. 06602

MANUFACTURING ENGINEERING DEPARTMENT

TOOL INSTALLATION TOOL
FUNCTION INSTALL SEAL INTO MAIN SHAFT

DESIGN DATE	P.E. APPVL DATE	SCALE
J. CHANG 5/20/94	A. CALIENDO 6/29/94	FULL
CHECK DATE	T.D. APPVL DATE	SHT 1 REV
AR COLOMBO 6/27/94	AR COLOMBO 6/27/94	OF 1 --

76351-09600-044T046

CAD PRODUCED 34X44

OUTSTANDING T.D.C.R.'S

ABBREVIATIONS & SYMBOLS

P.E.S. ....PRODUCTION ENGRG SPEC
S.T.M.M. ...STANDARD TOOL MDN MANUAL
E.O. .....ENGINEERING ORDER
R.T.E. ....REQUEST TO ENGINEERING
S/A .....SIKORSKY AIRCRAFT
<.....SEE NOTE NO.

THIS DESIGN CONTAINS FINISHED STOCK SIZES IN THE B/M

NOTES UNLESS OTHERWISE NOTED

4000√	TORCH CUT
3000√	SAW CUT
250√	MACHINE
125√	MACHINE
32√	GRIND

TOLERANCES....ANGULAR ±1°
.....X ±.06 .....XX ±.02 .....XXX±.010
BREAK SHARP EDGES.....005 TO .015 R
FILLET RADII TO BE.....005 TO .030 R
CHAMFER TO BE.....045 X 45°
√ FINISH ON ALL UNDICATED SURFACES

RBS

UNDER REVIEW
URF 19-1294 19.1.08 (VM)